Work Order Monday, July 14, 20		•	*122	2311*			Page 1
Revision ID:	3499-2 Dunting Plate	·	Accept	*N900040	1100*	Setup Start Stop	*NS1* *NS2*
Start Date: 7/1 Required Date: 7/1 Reference:	14/14 Start Qty: 14/14 Req'd Qty:	• •		Cust Item ID: Customer:			•
Approvals: P	rocess Plan:MUT	•	Tooling: SPC (Y/N):	Date:		Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Flan Accept Code Qty		Reject Insp. Number Stamp
Draw Nbr	Revision Nbr				,	,	
D3499	Rev C						
100 <b>*1 \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\</b>	FLOW WATE	R JET	0.00	,	2	<u> </u>	De 14/09/07
FLOW CNC Waterjet	D <sup>,</sup> Pr	Cut as per Dwg D3499 wg Rev: rog Rev: Deburr if necessary					
110	QC2- Inspect p	parts off machine FAI/FAIB	0.00				, /
*110* QC Quality Control	M	Iemo &	0.00				De 14/09/0
Quanty Control					0	Ø.	
120	QC8- Inspect	parts - second check	0.00				DA: <b>38</b>

0.00

Memo

\*120\*

Quality Control

DQA:			. Date: _										"DART
QA Closed:			Date:			WORK ORDER NON-	·CC	ONFOF	RMANCE / UI		ork Order up	date only	AEROSPACE
			***			DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Work Orde	er: _										ì	\4/545 m 154	]
						Rework			Skid-tube	Crosstube	0	Water Jet	Engineering
Part N	۰ ۱۵۰					Scrap			Machining	Small Fab	1	d. Eng. Coor.	Quality Other
NICO A	1.					Use-as-is			noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	
NCR N	۱O		·	<u>.</u>		Suspected Unapproved			raige ran	Composite	j	Supplier	
Root					Desc	ription of work order update	ı	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design													
Doc/Data			1										
Equip/Tooling													
Handling/Pre	Щ												
Material	Ш						İ						
Operator	_												
Offset/Setup													
Process	Ш												
Supplier													
Training	Щ												
Transport	Щ		}										
Unapproved				<u> </u>			<u> </u>					<u>.</u>	
1 1:			<u> </u>			General	FA	ULI CA	regory				
Landi	ng e	Bending			-	Bend	_	leolio/E	rogram		Outside Dim	ensions [	Pressure/Forced
	Н		ot Concer	ntric	-	BOM/Route	$\vdash$	Grain	Togram		Over/Under	ļ	Set-up
	Н	Cracks	ot concer	iitiic	-	Broken/Damage/Defect	$\vdash$	Hardwa	ire	-	Part Incorre	_	Temperature/Cure
	H	ł	nk/Ripple	/\ <i>M</i> /2\/A	<u> </u>	Burrs	H	4	ion Incomplete/U	ngualified	Part Lost/Mi	<u> </u>	Weld
	$\vdash$	Cuffs	niy nippic	., *****		Contamination	$\vdash$	1 '	tions Incomplete/	· ·	Part Moved		Wrong Stock Pulled
	H	Crushing	ı			Countersink	_	4	ned/off center		Positioned V	∟ Vrong	<b>_</b>
	$\vdash$	Heat Tre			$\vdash$	Cut Too Short		Mislabe			Power Loss/	_	Other
	-	4	on Strip in	Tube	-	Drawing		Misrea		<b>L</b> .	······································		
	$\vdash$	Marks/C	•			Drill Holes	$\vdash$	Off-set					
	<u></u>	4	Sequence	<b>!</b>		Finish		-	Calibration		***************************************		
		4	wist in Tul			Fit/Function		<b>-</b> 1 ' '	Sequence				

Work Orde Monday, July 14					Page 2							
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3499-2  Mounting Pla  7/14/14  7/14/14	start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	Accept	*N900  Cust Item I Customer:		100	)*	-	Start Stop	171.	S1* S2*
Reference: Approvals:	Process Pla		Date:	Tooling: SPC (Y/N):		nte:		·	Run	Start Stop	^I\ <u>\</u>	R1* R2*
Sequence ID/ Work Center I 130 *120* Small Fab Small Fab	D	Operation Description  Small Fab  Memo Deburr if ne	cessary.	Set Up/ Run Hours 0.00	Tool ID	Tool #  DAS 30 9-89	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
140 <b>*1 1 1 1 1 1 1 1 1 1 </b>		NC BRAKE  Memo	Dwg D3499	0.00		DAS <b>30</b> 9-89		· G		-		. 14

150

\*150\*

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DQA:			Date:			•							TRAC
				è		WORK ORDER NON-	-CC	ONFO	RMANCE / UP		101		AEROSPACE
QA Closed:		*	Date:							VV	ork Order up	date only	
Work Orde	r:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orac	-					Rework	1		Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	۱٥.					Suspected Unapproved	]		Large Fab	Composite	]	Supplier	
	<sub>T</sub>		T		Doss	ription of work order update		nitial	Acti	on	Sign &		
Root		Data	Ston	Otv	Desc	or non-conformance		ief Eng	Descri		Date	Verification	QC Inspector
Cause		Date	Step	Qty		or non-comormance		iei Liig	Descri	ption	- Date	Vermeation	Qe mapector
Design Doc/Data	$\dashv$											:	
Equip/Tooling	-												
Handling/Pre									-				
Material	$\vdash$		•	<u> </u>	•								
Operator					ļ								
Offset/Setup			1	Ì									
Process			ļ						i				
Supplier											İ		•
Training													
Transport													·
Unapproved								.,		<u></u>			
							FA	ULT CA	TEGORY			<u> </u>	
Landi	ng (	Gear				General		1		<b></b>	7	_	<b>-</b>
		Bending				Bend	_	4	Program	<u></u>	Outside Dim	<b>⊢</b>	Pressure/Forced
	<u> </u>	1	ot Conce	ntric	_	BOM/Route	_	Grain		ļ	Over/Under	<del>-</del>	Set-up
	$ldsymbol{ld}}}}}}$	Cracks			_	Broken/Damage/Defect	_	Hardwa			Part Incorre	<u> </u>	Temperature/Cure
1.	<u> </u>	Crimp/Ki	nk/Ripple	e/Wave	<u> </u>	Burrs	<u> </u>	1 '	ion Incomplete/Un	<u> </u>	Part Lost/M	· -	Weld
		Cuffs			-	Contamination	<u> </u>	4	tions Incomplete/L	Inclear	Part Moved	<u> </u>	Wrong Stock Pulled
		Crushing		•	<u> </u>	Countersink	$\vdash$	-1	gned/off center		Positioned V		٦٠
		Heat Tre			-	Cut Too Short	-	Mislab			Power Loss/	Surge	Other
		Inspectio		Tube		Drawing	-	Misrea					
		Marks/Cl			<u> </u>	Drill Holes	$\vdash$	Off-set			_		
	<u></u>	4	Sequence		-	Finish	$\vdash$	┥	Calibration				
		Wave/Tv	vist in Tul	be		Fit/Function		Jout of	Sequence				

Work Order ID 12	<b>22</b> 3	11
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\*122311\*

Page 3

Monday, July 14, 2014 1:55:39 PM **Item ID:** D3499-2 Accept \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Mounting Plate **Start Date:** 7/14/14 Start Qty: 8.00 \*8\* **Cust Item ID:** Required Date: 7/14/14 Req'd Qty: 8.00 \*8\* **Customer:** Reference: Start Run Tooling: Date: \_\_\_\_\_ Date: **Approvals:** Process Plan: Stop Date: \_\_\_\_\_ SPC (Y/N): Date: Reject Reject Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Insp. Accept **Work Center ID Description** Code Qty Qty Number Stamp **Run Hours** Chemical Conversion Coat per QSI005 4.1 160 0.00 £ 14-10-07 \*160\* 0.00 HandFinish Memo Hand Finishing White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 170 8 d K1-10-7. m129808 \*170\* Powdercoat 0.00 Memo START TIME: Powder Coating **OVEN TEMPERATUR** FINISH TIME: QC3- Inspect Part Finish 0.00 180 \*120\* QC 0.00 Memo Quality Control

DQA:			Date:			MODIL ODDED MON	~							`DART
QA Closed:			Date:			WORK ORDER NON-	-((	JNFUI	RIVIAINCE / UI		Wo	ork Order up	date only	AEROSPACE
<del></del>						DISPOSITION				AGAINST	DEI	PARTMENT	PROCESS	
Work Orde	r: _										_		\4/a4a# 1a4	7
Part N	lo					Rework Scrap Use-as-is		ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo			<del>,</del>		Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Desc	ription of work order update	١	nitial	Act	ion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design														
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Equip/Tooling														
Handling/Pre						· ·								
Material		4												<u> </u>
Operator	_													
Offset/Setup														1
Process													•	
Supplier														
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Transport														
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							FA	ULT CA	regory			<del></del>		
Landi	ng G	iear				General		n .			_	1 .	_	¬ !
		Bending				Bend	_	- '	rogram		_	Outside Dim	<u> </u>	Pressure/Forced
٠.		Centre No	ot Conce	ntric	L	BOM/Route	<u></u>	Grain				Over/Under	<del> </del>	Set-up
	Ш	Cracks				Broken/Damage/Defect	<u></u>	Hardwa			L	Part Incorre	<del> </del>	Temperature/Cure
	-	Crimp/Kir	nk/Ripple	e/Wave	L	Burrs	<u>_</u>	4	ion Incomplete/U			Part Lost/Mi	issing	Weld
	_	Cuffs			$\perp$	Contamination	$\vdash$		tions Incomplete/	Unclear	<u> </u>	Part Moved		Wrong Stock Pulled
	$\vdash$	Crushing			<u> </u>	Countersink	$\vdash$	1	ned/off center		<u> </u>	Positioned V		ا ا
	$\vdash$	Heat Trea				Cut Too Short	<u> </u>	Mislab				Power Loss/	Surge	Other
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		Marks/Ch				Drill Holes	$\vdash$	Off-set						
		Turning S	-			Finish	<u></u>	-	Calibration					
		Wave/Tw	ist in Tu	be	1	Fit/Function	<u> </u>	Out of	Sequence					

Work Ord				*122	2311*						Page
Item ID: Revision ID: Item Name:	D3499-2  Mounting Pla	ate		Accept	*N900	<b>040</b>	100	)*	Setup Sta	! //	S1* S2*
Start Date: Required Date Reference:	7/14/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D;			D 54a		
Approvals:	Process Pl	lan:	Date:	_ Tooling: _		ate:			Run Sta Sto	^IVI	R1*
	QC:		Date:	_ SPC (Y/N):	Da	ate:				×I/I	Hン*
Sequence ID/ Work Center	ID	Operation Description Identify as per dwg & St	ock Location:5 <del>12</del> 6	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS  66
*1QA* Packaging		Memo		0.00				<u>メ</u> _	OCT 1 4 2	2014	9-89

200

Packaging

QC21- Final Inspection - Work Order Release

0.00

\*200\*

Memo

0.00

Quality Control

Page 4

14/10/15 95 MF 14-10-15

DQA:		Date:										•	TRAC"
QA Closed:	,	Date:			WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE	Wo	ork Order up	odate only		AEROSPACE
					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
Work Order	:					.			_		_	_	- · · □
					Rework			Skid-tube Crosstube	_	D	Water Jet	-	Engineering
Part No	)·				Scrap			Machining Small Fab	-		d. Eng. Coor. re/Packaging	$\dashv$	Quality Other
NCR No	1				Use-as-is Suspected Unapproved		men	Large Fab Composite	$\vdash$	Nec/3to	Supplier	$\dashv$	
, , , , , , , , , , , , , , , , , , ,	··					,							<u> </u>
Root				Desc	ription of work order update	ı	nitial	Action		Sign &			
Cause	Da	te Step	Qty <sup>*</sup>		or non-conformance	Ch	ief Eng	Description		Date	Verification	4	QC Inspector
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	Bend	ing		_	Bend		4 .	Program	┕	Outside Dim		_	Pressure/Forced
		re Not Conce	entric	<u> </u>	BOM/Route	<u></u>	Grain			Over/Under	F-	_	Set-up
	Crac			_	Broken/Damage/Defect	<u> </u>	Hardw		<u> </u>	Part Incorre	<b>—</b>	_	Temperature/Cure
	_	p/Kink/Rippl	e/Wave	L	Burrs		1 '	tion Incomplete/Unqualified	┡	Part Lost/M			Weld
\ <u> </u>	Cuff			<u> </u>	Contamination	_	4	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
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	<b>⊣</b>	Treat		<u> </u>	Cut Too Short	<u> </u>	Mislab			Power Loss/	Surge		Other
-	<b>-</b>	ection Strip in	n Tube	$\vdash$	Drawing	$\vdash$	Misrea						
-		ks/Chatter		<u> </u>	Drill Holes	$\vdash$	Off-set						
-		ing Sequence		<u> </u>	Finish	$\vdash$	4	Calibration					1,000
	Wav	e/Twist in Tu	ıbe		Fit/Function	1	Out of	Sequence					

## **Picklist Print**

Monday, July 14, 2014 1:55:39 PM

Work Order ID: 122311

\*122311\*

Parent Item:

D3499-2

\*D3499-2\*

Parent Item Name: Mounting Plate

**Start Date:** 7/14/14

Required Date: 7/14/14

Page 1

Start Qty: 8.00

Required Qty: 8.00

**Comments:** 

IPP Rev: A New Issue 06-05-05 JLM

IPP Rev:B As per Rev B 06-08-31 JLM

IPP Rev:C as per dwg

revC DD 10.02.23 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No		100	sf	147.4730	1.068	8.993684			
*M6061T6	SS 125*							**			Del	4/09/07

<b>Location</b>	Loc Qty	Loc Code	
MAT021	147.473		
m127272	36.5		
m127454	59.833		(19)
m127501	9.6		
m128852	41.54		

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Part Number: D3499-2	DART AEROSPACE LTD	Work Order:	122311
Description: Mounting Plate Part Number: D3499-2	DART ALROOF AGE 115		D2400 2
Description: Mountaing : late	Description: Mounting Plate	Part Number:	D3499-2
Page 1 of 1	Description: Mountaing Floris		Do = 0 4 of 1
Inspection Dwg: D3499 Rev: C	Inspection Dwg: D3499 Rev: C		Page 1 01 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
51.000	+/-0.010	51.00	/		10-WIC=1	
47.67	+/-0.030	47.67	/		T=3km-06	
Ø0.201	+0.005/-0.001	, 204				
25.500	+/-0.010	25,500	/			
Ø0.220 x 0.38	+/-0.030	. 225x.379				
2.500	+/-0.010	7.500				
3.016	+/-0.010	3 .026	/			
0.500	+/-0.010	1500	/			
R0.25	+/-0.010	125				
Ø0.500	+0.006/-0.001	-479				
0.125	+/-0.010	.122				
<u> </u>						
			DAS			

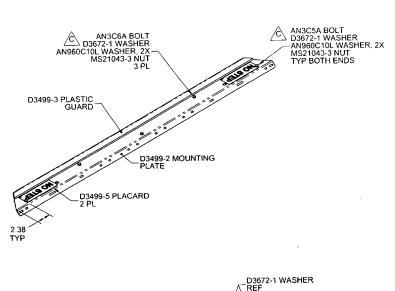
Measured by: Date: Audited by: 9-89

Date: 14/09/07

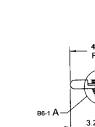
Date: 14-9-11

Pavised by Approved

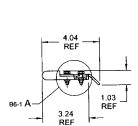
			Revised by	Approved
Rev	Date	Change	KJ/JLM	
Α	06.06.22	New Issue	KJ/JLM	
В	06.08.31	Dimensions updated per D3499 Rev. B	KJ/DD 10	
С	09.05.04	Dimensions updated	KJ/JLM CX	W
D	13.06.03	Dimensions updated per Dwg Rev. C	7/	
		•	V	



AN3C6A BOLT



45.57 REF



51.00

ITEM	QTY -042	P/N	DESCRIPTION			
11	X	D3499-042	CABLE GUARD ASSEMBLY			
2	1	D3499-2	MOUNTING PLATE			
3	1	D3499-3	PLASTIC GUARD			
4	2	D3499-5	PLACARD			
5	2	AN3C5A	BOLT			
6	3	AN3C6A	BOLT			
7	10	AN960C10L	WASHER			
8	5	MS21043-3	NUT			
9 5 D3672-1		D3672-1	WASHER			

SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 122311 MLJ 1407-15

ND

С	DRAWING UPDATED TO CURRENT STANDARDS 3.245 WAS 3.255 (ZN 88-3), 3.24 WAS 3.25 (ZN D3-3), REVISE TOLERANCE 8.201 WAS 2.00 (ZN D3-3), 0.0872-1 WAS NAS1515H3I, (ZN D3-1, D5-1, D7-1), ADD IDENTIFY NOTE (ZN 84-1), REF NCR-09-045				09.06.19	
В	RE-DES	E-DESIGN D3499-2F/-3			06.08.15	
Α	NEW IS	SUE	j		06.04.11	
REV.			DESCRIPTION		DATE	
DESIGN RF			DART AEROSPACE USA, INC.			
		R-F	PORT HADLOCK, WA			
CHECKED		ill	DRAWING NO.		REV. C	
MFG. APPR. 1E		180	D3499		SHEET 1 OF 4	
APPROVED			TITLE		SCALE	
DE APPR.		-#	CABLE GUARD N		NTS	
DATE	09.0	06.19	COPYRIGHT © 2006 BY DART AL THIS DOCUMENT IS PROVIDE AND COMPOSITION AND IS SUPPL NOT TO BE USED FOR ANY PURPOSE OR COPYED OR COMPUTA	ED ON THE EXPHIT	SS CIONDITION THAT IT IS	

## D3499-042 CABLE GUARD ASSEMBLY

AN960C10L WASHER-REF

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3499-041/-042" USING FINE PÓINT PERMANENT INK MARKER
7) WEIGHT: 3.90 lbs

D

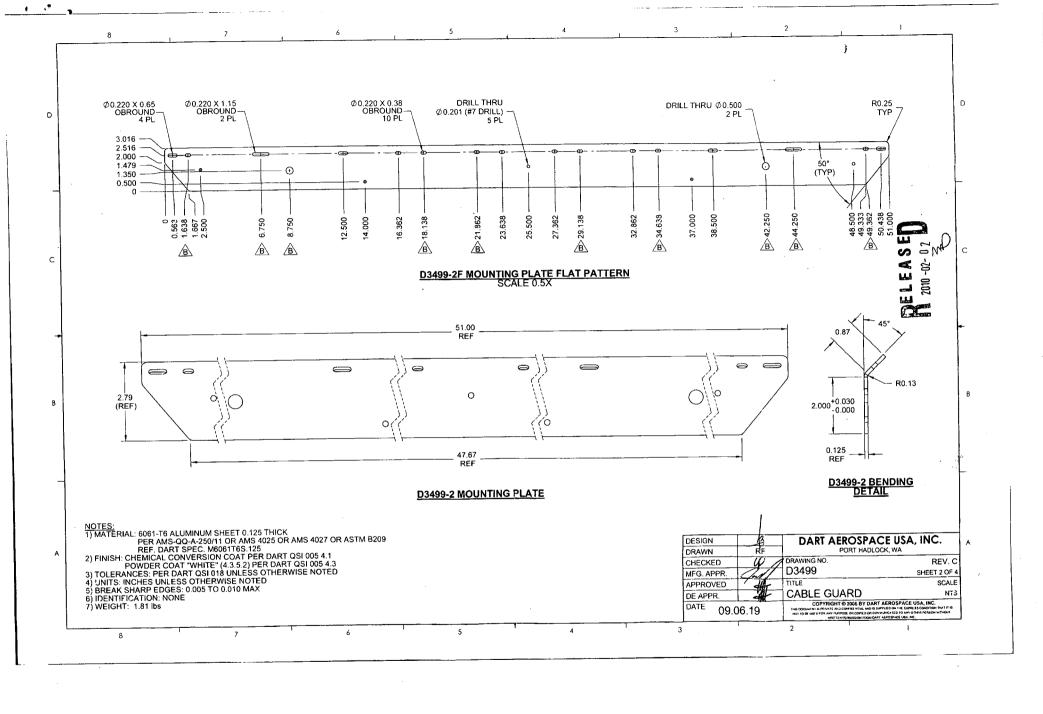
В

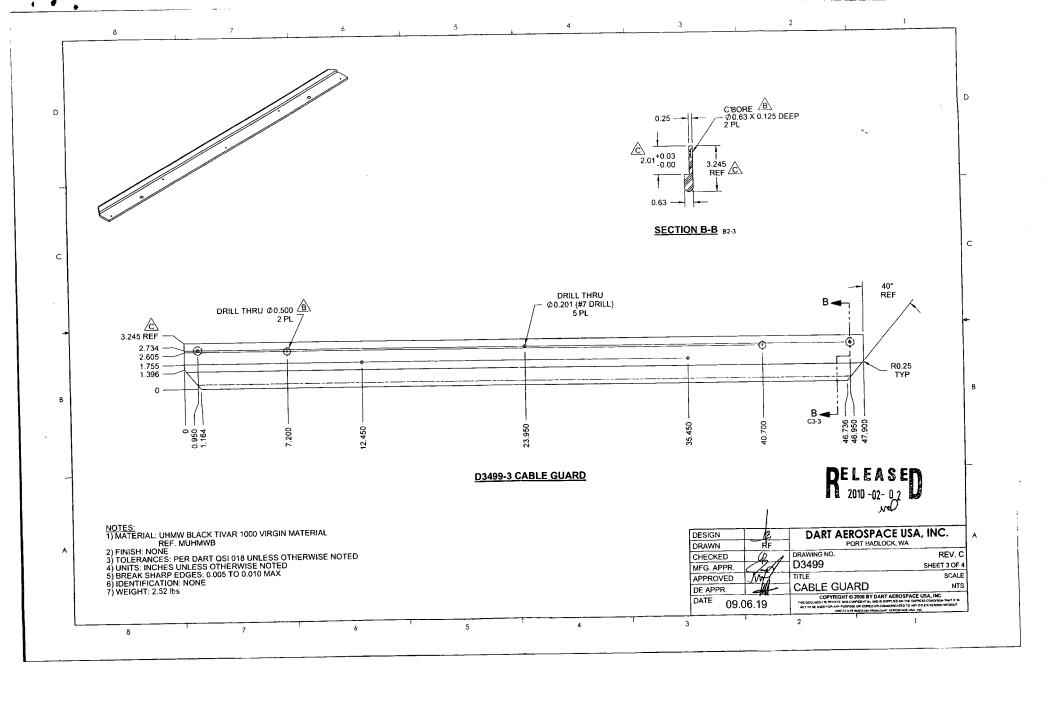
AN3C5A BOLT

MS21043-3 NUT

DETAIL A B4-1

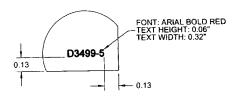
D





FONT: ARIAL BOLD RED -TEXT HEIGHT: 0.88" TEXT WIDTH: 5.17" 0.43 NO STEP 1.75 0.44

D3499-5 PLACARD



DETAIL C B5-4

DART AEROSPACE USA, INC. DESIGN DRAWN REV. C DRAWING NO. CHECKED D3499 SHEET 4 OF 4 MFG. APPR. SCALE TITLE APPROVED **CABLE GUARD** DE APPR. COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

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AND TO SEE USED FOR ANY PROPERCY OF CONTENT OF ON CONFIDENTIAL AND THE PROPERCY OF CONTENT OF ON CONTENT OF THE PROPERCY OF THE DATE 09.06.19

NOTES:
1) MATERIAL: RED LETTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00° LONG° x 1.75° WIDE

2) FINISH: N/A
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE 7) WEIGHT. N/A

D